

Date: Tuesday, 27/03/2007 10:00:53 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 31515		
Estimate Number	: 11178		
P.O. Number	: N/A	Part Number	: D32931
This Issue	: 27/03/2007 S.O. No. : N/A	Drawing Number	: D3293 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 29240	Material	: N/A
Written By	:	Due Date	: 03/04/2007 Qty: 4 Um: Each
Checked & Approved By	:		
Comment	: Est:A 04.08.24 New issue KJ/JLM Est Rev:B Now on Waterjet 06-11-02 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S080	2024-T3 .080 sheet
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Comment: Qty.: 1.9177 sf(s)/Unit Total : 7.6709 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.080" thick
 (M2024T3S.080)
 Identify for D3293-1
 Batch: M102838 ml 07 03 27

(4)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3293
 Dwg Rev: A ml 07 03 27
 Prog Rev: A
 2-Deburr if necessary

(4)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

(4)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

ml 07 03 27 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/03/08

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 27/03/2007 10:00:53 AM
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Drawing Name: DOUBLER

Job Number: 31515

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr

SB 07/03/27 (4)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

U 07/03/27

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MS

07-03-27 (4)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M100700

MS

07-03-27 (4)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/3/27 (4)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/3/27 (4)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/28 (4)

Job Completion



U 07-03-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QA COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
CHECKED	APPROVED		DRAWING NO.
DATE		TITLE	SHEET 1 OF 1
04.06.28		DOUBLER	SCALE 1:3
A	04.06.28	NEW ISSUE	

D3293-1 DOUBLER

MAKE PER DRAWING FILE "D3293-A1.DWG"

CHECK PER TEMPLATE D3293-1T1

DIMENSIONS SHOWN FOR REFERENCE ONLY

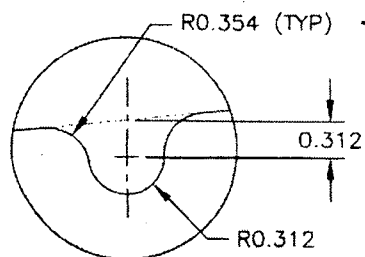
MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER

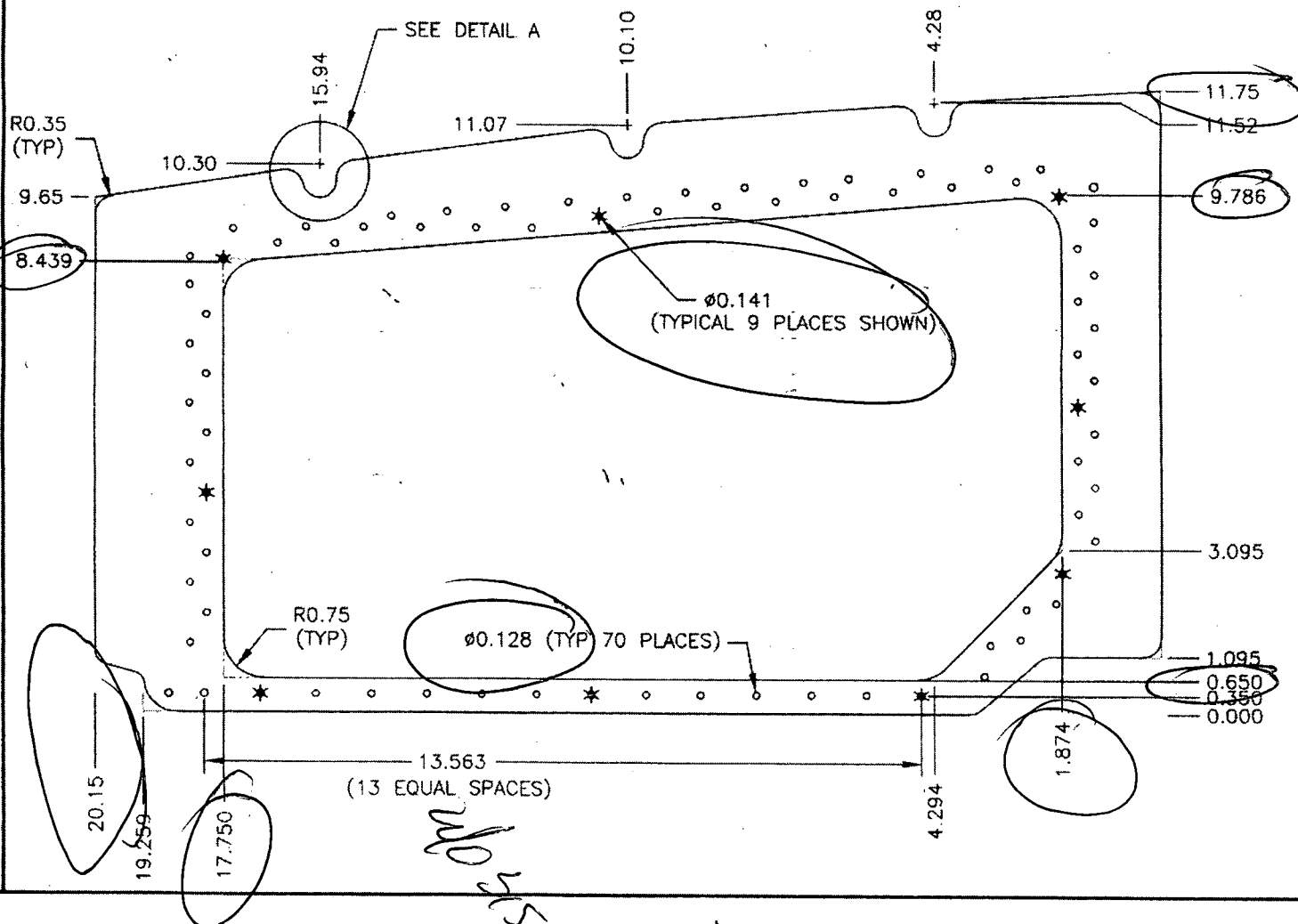
DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DETAIL A
SCALE 2:3

DO NOT
RELEASE
04 07 72 #



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

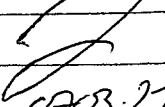
NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 31515
Description: Doubler		Part Number: D3293-1
Inspection Dwg: D3293 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $\phi 0.128$	$\pm 0.005, 0.001$	0.128	✓		VERN	
B $\phi 0.141$	$\pm 0.005, 0.001$	0.141	✓		VERN	
C 20.15	± 0.030	20.15	✓		Measuring tape	
D 11.75	± 0.030	11.73	✓		Measuring tape	
E 1.874	± 0.010	1.881	✓		VERN	
F 0.650	± 0.010	0.652	✓		VERN	
G 17.750	± 0.010	17.750	✓		Measuring tape	
H 8.439	± 0.010	8.440	✓		VERN	
I 9.786	± 0.010	9.790	✓		VERN	
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: M.M	Audited by: 	Prototype Approval:	N/A
Date: 01 03 27	Date: 07 03 27	Date:	N/A
Rev	Date	Change	Revised by KJ/RF
		New Issue	Approved